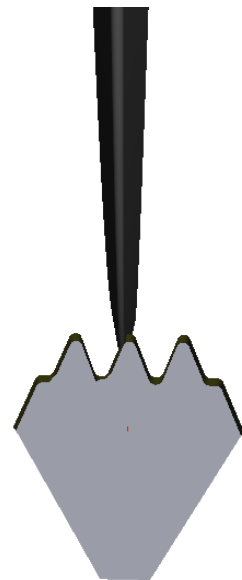
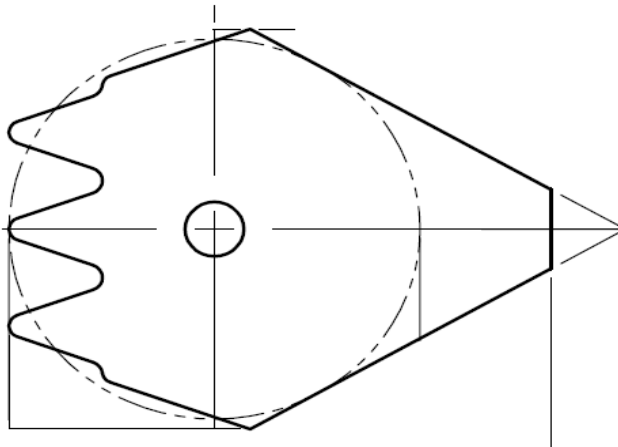









Insert DF356-3SR ID-Ø14.0

A08-010



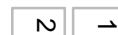
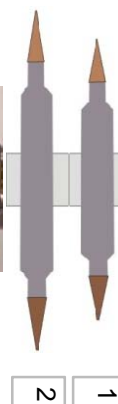
1. Cycletime for Production

Workpiece: 60° Ref ID-Ø14.0, T4.76 Material CARBIDE				
Operations				
PlungRough				
Pregrinding				
Finishing				
Load				
Feed [mm/Min]	15	20	20	9000
Power [kW]	4	3	2	1
Cutting speed [m/s]	20	20	22	
Used wheels				
Grinding time [s]	62	98	96	12
Total cycle time	4 Min 28			

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	14EE1 Ø200 D76V20°
2	14EE1 Ø250 D46V20°



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : SIRIUS HPM

Control: Fanuc 310i

Accessories: Loader STL6050, RPC clamping

Responsible engineer: OP, 21.5.15

Coolant: Synthetic Oil, pressure 6 bar

Software: Quinto 5

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